



ADVISORY NOTE #35

STEEL COMPOSITION

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TABLE OF CONTENTS

Contents

STEEL COMPOSITION _____	2
Introduction _____	2
The Effect of Steel Composition _____	2
Examples Of Aesthetic Appearances due to Varying steel Composition _____	4

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STEEL COMPOSITION

INTRODUCTION

Hot dip galvanizing (HDG) is a functional coating process providing superior protection against corrosion for steel articles when measured against most other coating systems. The corrosion resistance of a HDG coating (ISO 14713 and DR AS/NZS 2312.2) is normally directly related to the thickness of the coating (AS/NZS 4680).

Certain elements, in particular silicon (Si) and phosphorus (P), in the steel can affect HDG by prolonging the reaction between iron and molten zinc. Generally, this results in the outer pure zinc layer, which is responsible for the shiny metallic finish, being consumed and the dull grey zinc-iron alloys being exposed. This characteristic was first described by Sandelin in 1940 and is schematically described in Figure 1.

In addition, the steel composition can sometimes affect the coating's resistance to materials handling damage. The prior history of the steel (e.g. whether hot rolled or cold rolled) can also affect its reaction with molten zinc. Therefore, certain steel compositions achieve more consistent coatings than others with regard to appearance, thickness, materials handling and smoothness.

THE EFFECT OF STEEL COMPOSITION

Where aesthetics are important or where particular coating thickness, materials handling or surface smoothness criteria exist, specialist advice on steel selection should be sought prior to fabrication of the article or hot dip galvanizing. Steels with the chemistry shown in Category A & B (see **Figure 1** & **Table 1**) usually provide the best results for aesthetics and corrosion protection respectively. Australian-made structural steels normally comply with the minimum coating thickness requirements of AS/NZS 4680.

Steels with chemistry shown in Category X (Si ≤ 0.01%) in **Table 1** are deoxidised with aluminium in the manufacturing process (known as aluminium fully killed, fine grained steels). These steels sometimes produce coating thicknesses under the AS/NZS 4680 requirements using normal galvanizing processes.

For steels known to produce thinner coatings, abrasive blasting the steel surface prior to galvanizing will increase the surface area and usually produce a thicker coating. This can change the appearance of the galvanized article and/or increase the roughness of the finished surface and will increase the cost of the finished article. It is therefore best practice to consider the durability requirement of the article prior to requesting blasting of the steel if the coating thickness achieved without blasting will meet the specified design life.

Steels with the chemistry shown in Category C & D (**Table 1**) are known as highly reactive steels and these can cause thick galvanized coatings to form. These thicker coatings are also known to be somewhat less resistant to handling compared to the standard coating; however, they can also provide increased corrosion resistance.

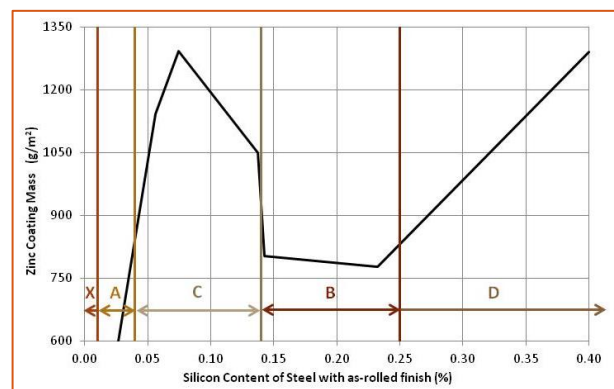


Figure 1: The Sandelin curve

ADVISORY NOTE #35

Table 1: Typical coating characteristics related to steel composition

Category	Si & P relationship	Appearance	Resistance to mechanical damage	Mass of coating	Typical use
X	$Si \leq 0.010\%$	Excellent, typically shiny	Excellent	Minimum. Can sometimes be under Standard	For aesthetic and corrosion protection
A	Hot rolled $Si \leq 0.040\%$ $Si+2.5P \leq 0.090\%$	Excellent, typically shiny	Excellent	Standard. Generally superior to the normal requirement	For compliance with Standard and excellent corrosion protection
	Cold rolled $Si + 2.5P \leq 0.04\%$				
B	$0.14\% < Si \leq 0.25\%$	Good, can tend to mottled or dull with increasing steel thickness	Good	Always heavier than normal. Best specification for corrosive environments	Optimum long-term corrosion protection
C	$0.04\% < Si \leq 0.14\%$	Can be dark and coarse	Reduced	Extra Heavy	In non-abrasive environments can provide extreme corrosion protection
D	$Si > 0.25\%$				

Note: The presence of alloying elements (e.g. nickel) in the zinc melt can have a significant effect on the coating characteristics indicated above.

ADVISORY NOTE #35

EXAMPLES OF AESTHETIC APPEARANCES DUE TO VARYING STEEL COMPOSITION

Example 1: Shiny and dull



Above: Two fabrications with different steel compositions after being galvanized at the same time. The dull grey coating is typical of steel from Categories C & D while the shiny appearance is typical of steel from Categories X & A. Both products comply with AS/NZS 4680.

Example 2: Mottled and/or patchy

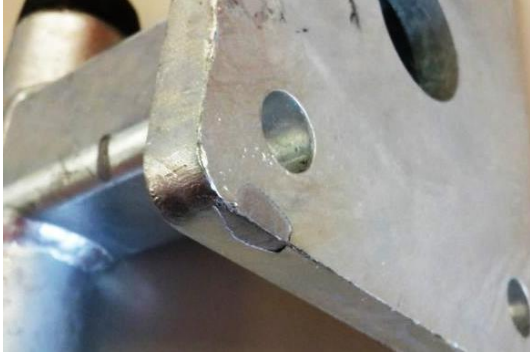


Above: This galvanized pipe's steel composition is likely to be in Category B, shown by the scale-like or mottled appearance of the coating, where some of the Fe/Zn alloy has extended through to the surface. This product complies with AS/NZS 4680. Over time, the surface will change to a more even dull grey finish.

Above: The patchy appearance of this galvanized coating is due to both Si content and thickness of the steel. The areas of shiny appearance have cooled faster and pure zinc has solidified on the surface. The other areas have cooled at a slower rate and the galvanizing reaction continued until the pure zinc was consumed and only dull zinc-iron alloys are showing at the surface. This can occur with steels in Category B and complies with AS/NZS 4680. Over time, the surface will change to a more even dull grey finish.

ADVISORY NOTE #35

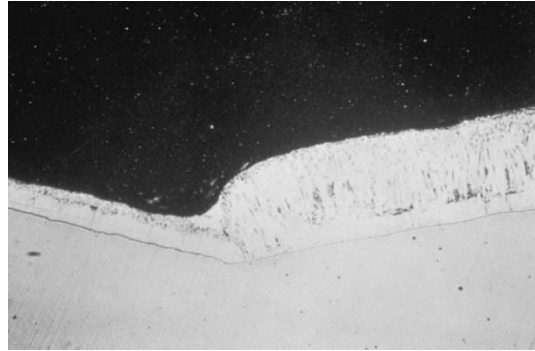
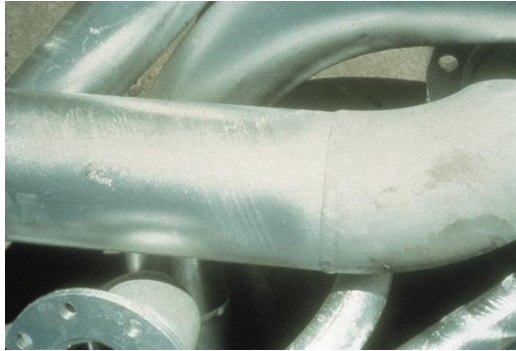
Example 3: Chipping and flaking



Above: Handling has caused some damage to the edge of this thick galvanized coating, where some of the coating has been chipped. Thick coatings can result when steels from Categories C & D are galvanized. It is likely the coating will still meet the thickness requirements of AS/NZS 4680, and is acceptable, so long as the remaining product firmly adheres to the substrate.

Above: Category D steels are most likely to produce a galvanized coating where thick, brittle Fe/Zn alloy layers are formed and flaking occurs due to the excessive coating thickness. This article will not meet the requirements of AS/NZS 4680 due to the excessive flaking and should be rejected.

Example 4: Thin and thick coatings



Above: The shiny surface (to the left) is typical of Category X, A & B, while the duller coating (to the right) is typical of Category C & D. Over time, the both coatings will weather and tend towards a similar dull grey colour. This product meets the requirements of AS/NZS 4680.

Above: The join between the shiny and dull coatings of the pipe fabrication to the left showing the thinner coating typical of Category X, A & B compared to the typical thicker and more brittle coating achieved with Category C & D.

Galvanizers Association of Australia
Level 5, 124 Exhibition Street
Melbourne, VIC, 3000
Australia

T: +61 3 9654 1266
E: gaa@gaa.com.au
W: www.gaa.com.au
Life Cycle Cost: <http://lccc.gaa.com.au>

galvanizers
ASSOCIATION OF AUSTRALIA